

Work Order ID 59021



Page 1

May 25, 2010 7:32:28 AM

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/25/10

Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty.

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3564	Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

HB 10-5-25

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

HB 10-5-25

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

D. (x 11) / S
10/05/25 / 10/05/25
10/05/25 - (14) → PT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3564-11 PAR #: Fault Category: Small Fob / W. Jet NCR: Yes No DQA: *J* Date: 10/06/02
 Resolution: *Scrap* Disposition: *Scrap* QA: N/C Closed: *FJ* Date: 10/06/02

NCR:59021		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/02	# 100	Found QH +1 at inspection with cut out inside First .300 + .300 hole (Prod.) Level in - Lead out.	<i>QSL042</i>	Scrap & Destroy no Replace QH +1	<i>B 10/05/02</i>	<i>S 10/05/02</i>	<i>QSL042</i>	<i>S 10/05/02</i>
		R.C: Machine mal function. EQPT tooling/Function						

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Brake NC

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

SB 10/05/26

11

8

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

S.10/05/26

11

150



Large Fab

0.00

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
 Weld hardcoat as per Dwg D3437

M 114460

Q 10-5-27 X/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59021

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Item ID: D3564-11

Accept



Setup Start



Revision ID:

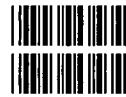
Item Name: Wearshoe

Stop



Start Date: 5/25/10

Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

8.05/27



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

8.05/27



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

1112588
=> 10/05/25

Powdercoat

Powder Coating

Memo

START TIME: 7:15AM OVEN TEMPERATURE:
FINISH TIME: 7:45AM 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59021

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May 25, 2010 7:32:29 AM

Item ID: D3564-11

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/25/10

Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

190

QC3- Inspect Part Finish

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

11 BR 10-5-28

QC

Memo

Quality Control

200

Identify as per dwg & Stock Location:



EP-19

0.00

11 10/05/28

0.00

11 Ø

Packaging

Memo

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

0.00

10/06/01 JJ
CL 10/15/28

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 25, 2010 7:32:26 AM

Page 1

Work Order ID: 59021



Parent Item: D3564-11



Parent Item Name: Wearshoe

Start Date: 5/25/10

Required Date: 5/31/10

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Start Qty: 12.00

Required Qty: 12.00

M304S16GA



Purchased No

100 sf 62.4548 1.41 17.81053



304/316 Sheet .063

18.0-5-25

Location	Loc Qty	Loc Code
MAT	62.4548	
111323	0	
114467	62.4548	114467

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

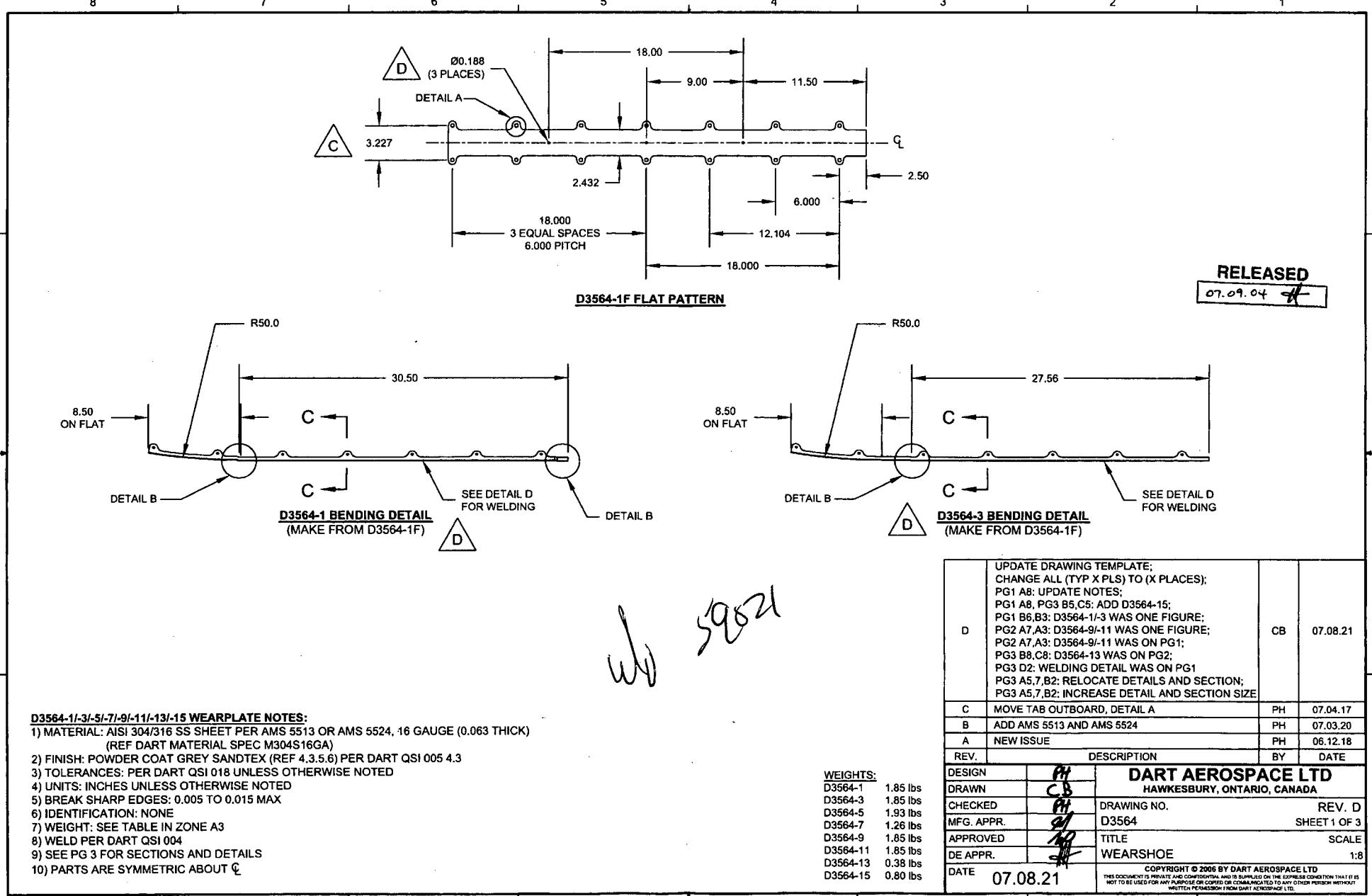
DART AEROSPACE LTD	Work Order:	5902
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	Mr. S	Prototype Approval:	N/A
Date:	10-5-25	Date:	10/05/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	24/12



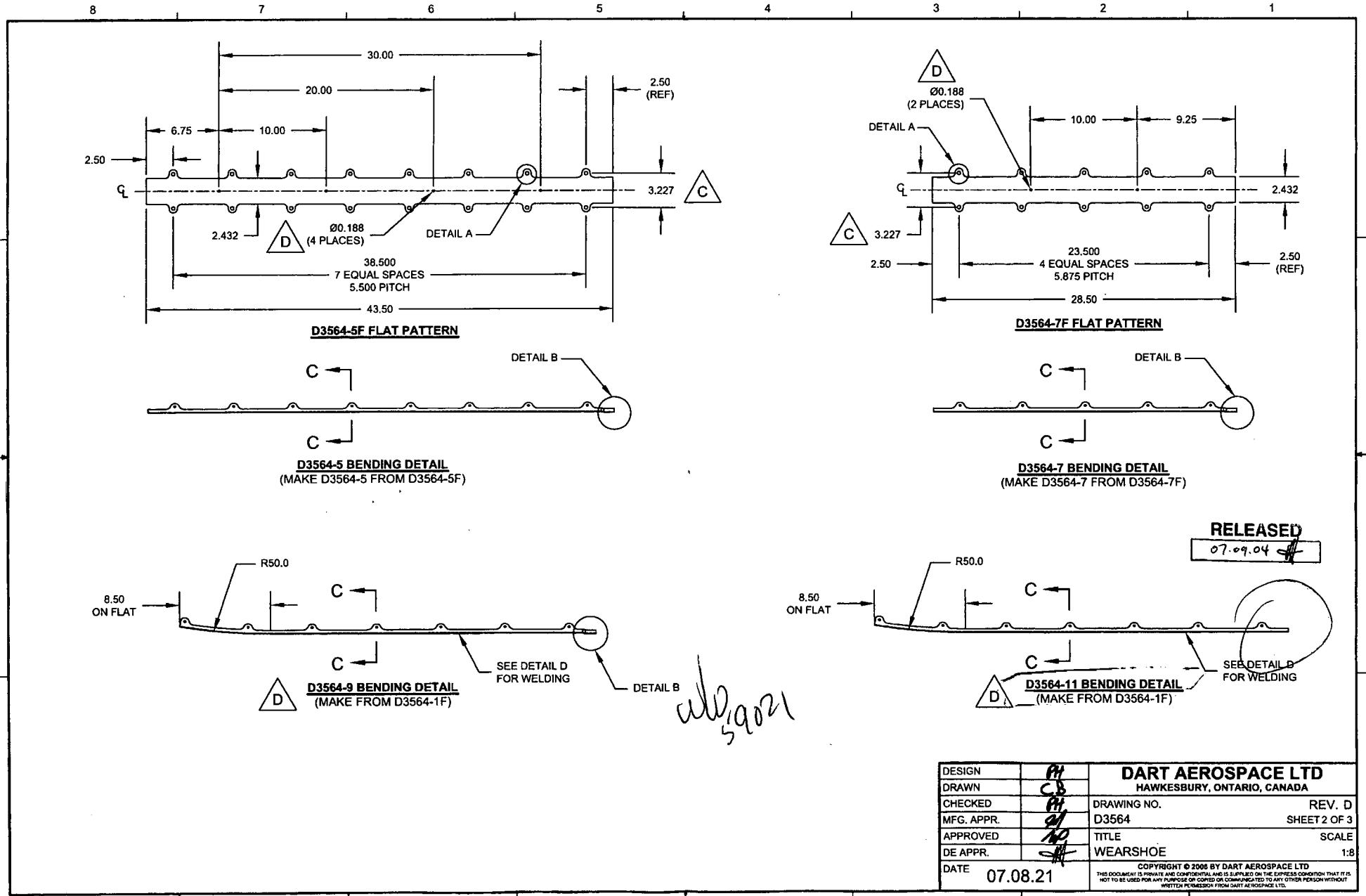
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

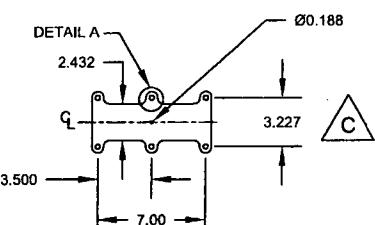


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

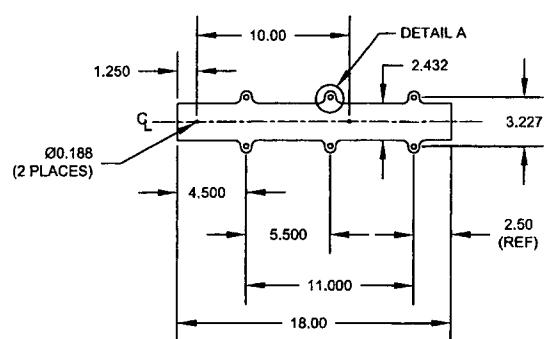
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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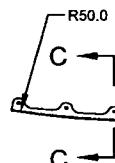
NOTE: Date & initial all entries



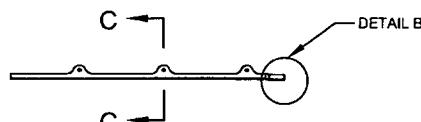
D3564-13F FLAT PATTERN



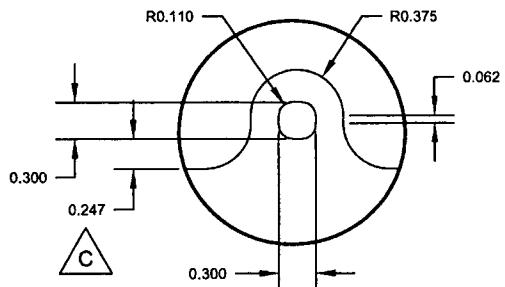
D3564-15F FLAT PATTERN



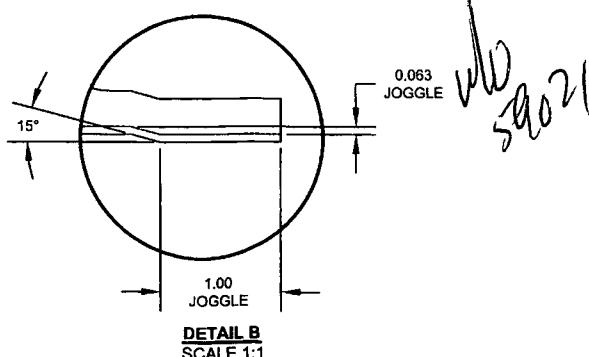
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-1)



DETAIL A
SCALE 1:1

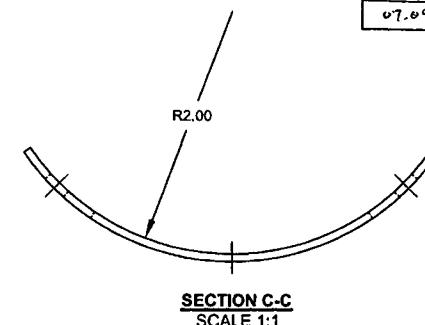


DETAIL B

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED
07.09.04 11



SECTION C-C
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	SI	D3564	SHEET 3 OF 3	
APPROVED	SP	TITLE	SCALE	
DE APPR.	SP	WEARSHOE	1:8	
DATE	07.08.21			

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